

Date:
User:Monday, 05/05/2008 8:25:00 AM
Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 39026 -1
 Estimate Number : 13300
 P.O. Number :
 This Issue : 05/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-05-01 new issue DD verified by:EC

Drawing Name : BRACKET

Part Number : D2127251061
 Drawing Number : D212-725-1 P.25REVB
 Project Number : N/A
 Drawing Revision : REV.B
 Material :
 Due Date : 12/05/2008 Qty: 5 Um: Eac

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.2730 sf(s)/Unit Total : 1.3650 sf(s)

2024-t3 0.040 Sheet

Batch: 107572 HB 8-5-6

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D212-725-1

Dwg Rev: B HB 8-5-6

Prog Rev: B

2- Deburr if necessary HB 8-5-6

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D212-725-1 p.25

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 39026

Part Number: D2127251061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/09

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

yl 08-05-09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-05-09

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PLS 08/05/09

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

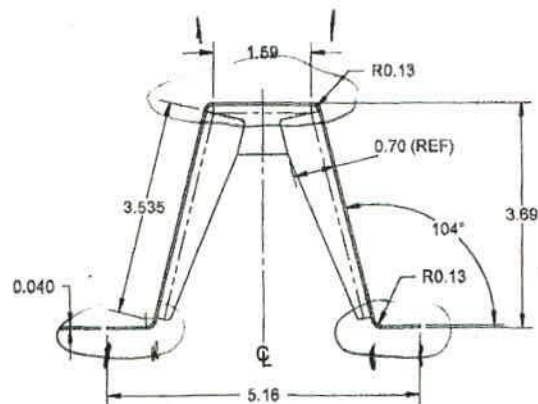
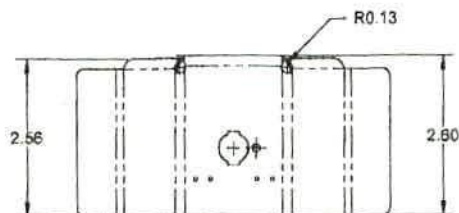
08/05/09

Job Completion



u 08/05/09

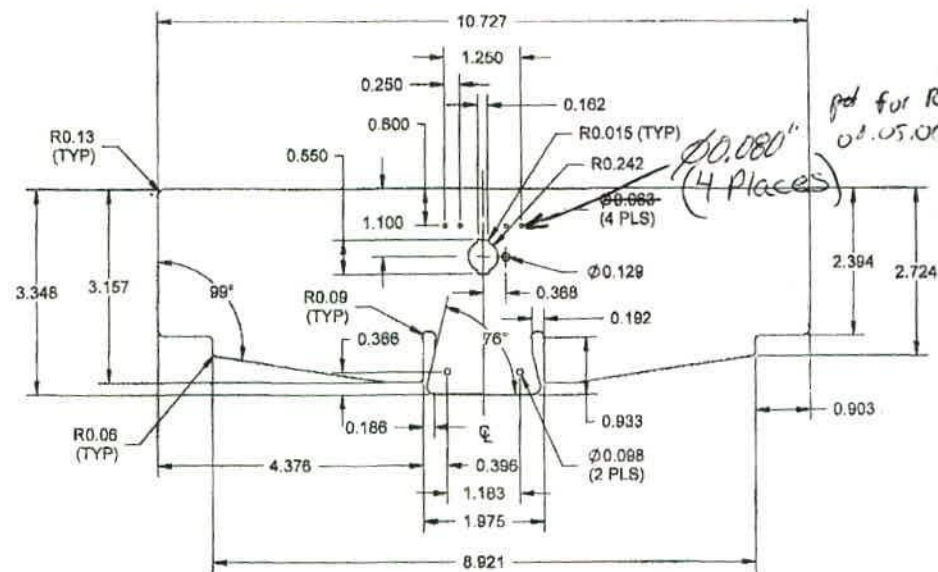
TRANSFER $\phi 0.129$ HOLE.
INSTALL MS20470AD4-4 RIVET
(2 PLS)



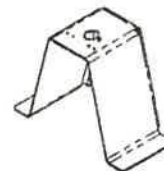
D212-725-1-061 BRACKET
(MAKE FROM D212-725-1-061F FLAT PATTERN)

NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



D212-725-1-061F FLAT PATTERN



B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED [Signature]	DRAWING NO. D212-725-1
DATE 07.05.11	TITLE 212S DETAIL PARTS	REV. B SHEET 25 OF 44
SCALE 1:2		

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